

Work Order ID 65754

Page 1

Tuesday, January 25, 2011 10:25:00 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 1-01-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

CK Per BG 11/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754

Tuesday, January 25, 2011 10:25:00 AM



Page 2

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE*

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004
AR Aluminum Rod Batch: M111385 / M116577

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP

11-1-26

11/01/27

BE 11/01/31

BE 11/01/31

BE

11/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754

Page 3

Tuesday, January 25, 2011 10:25:00 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Subtotal

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Subtotal

Quality Control

XU

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

DP

11-2-2

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754

Page 4

Tuesday, January 25, 2011 10:25:00 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1 0 BE 1/25/02

150



Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ 116040 ☐Sikaflex expire date: ☐ 11/09/10 ☐Start: ☒ 1/24/02 Time: ☒ 2:30 ☐Finish: ☐ Time: ☐

(Adhere for 12 hours)

11/02/03 @ 9:10 AM

1 0 BE 1/25/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754

Tuesday, January 25, 2011 10:25:00 AM

Page 5

Item ID: D206-642-541

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S u l o r l o s

40

170

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DP

11-2-3

DP

11-2-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754

Tuesday, January 25, 2011 10:25:00 AM

Page 6

Item ID: D206-642-541

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ M111385

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

BE 1/10/03
3 BE 4/02/07

1 0 BE 1/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754

Tuesday, January 25, 2011 10:25:00 AM

Page 7

Item ID: D206-642-541

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00

Required Date: 1/31/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



0.00 Subtotal

QC

Memo

Quality Control

210

QC10- Inspect visual per QSI004- ground welds

0.00



0.00 Subtotal

QC

Memo

Quality Control

220

Pressure Wash per QSI005 4.3

0.00



0.00

HandFinish

Memo

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

1 of 11/02/00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754



Page 8

Tuesday, January 25, 2011 10:25:00 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 115951

1 BL 11-02-8.

Powder Coating

Memo

0.00

START TIME: *3:50*
OVEN TEMPERATURE: *300°*
FINISH TIME: *4:20*

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BL 11/02/09

250

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/R ☐ N/A ☐ LPS-3 ☐ *M 1109956*

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a
A/R ☐ ☐ Sikaflex-291 ☐ *M 115114*
Sikaflex expire date: ☐ *11/01*

1 0 BL 11/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754

Page 9

Tuesday, January 25, 2011 10:25:00 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

11 02 09 ①

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 1115114 ☐Sikaflex expire date: ☐ 11/01

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 2/14

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 1115114 ☐Sikaflex expire date: ☐ 11/011 2 11/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65754

Tuesday, January 25, 2011 10:25:00 AM



Page 10

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 1/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 1/26/10

AD

290

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

AP 65285

11/2/16

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/02/16

MF

11-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 25, 2011 10:25:06 AM

Page 1

Work Order ID: 65754

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190 		Manufactured	No			110	Each	46.0000	1	1			
Extrusion Round 3" 206													

Location

Loc Qty

Loc Code

LG

46

47575

2

59874

44

D3285-1



Manufactured

No

110

Each

116.0000

1

1

Cap

Location

Loc Qty

Loc Code

LG

116

52511

68

52647

48

D3282-041



Manufactured

No

150

Each

11.0000

1

1

Float Web (206L/407)

Location

Loc Qty

Loc Code

LG

11

63389

1

65292

6

65293

4

DP 11-1-26

BE 11/01/31

Signature

BE 11/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 25, 2011 10:25:06 AM

Page 2

Work Order ID: 65754

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

327.0000

12

12



Cross Bolt Spacer



BE 11/02/03

Location

Loc Qty

Loc Code

LG

327

58545

2

60652

4

61496

2

62889

11

63359

3

65317

305

12

D3275-1

Manufactured No

190

Each

113.0000

12

12



Crossbolt Spacer



BE 11/02/03

Location

Loc Qty

Loc Code

LG

113

53453

8

62399

1

63546

19

65295

85

12

CR3212-4-03

Purchased No

250

Each

1,869.000

2



Cherry Rivet



2

11/02/09

Location

Loc Qty

Loc Code

ST311

1869

110153

35

111359

5

112314

2

114436

448

114450

33

114859

1346

M110139

Y2

Tuesday, January 25, 2011 10:25:07 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 25, 2011 10:25:07 AM

Page 3

Work Order ID: 65754

Parent Item: D206-642-541


Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011


Required Date: 1/31/2011

Start Qty: 1.00


Required Qty: 1.00

D3415-041 Manufactured No 250 Each 33.0000 1

 Nut Plate

Location	Loc Qty	Loc Code
ST056	33	
33842	33	

CCR264SS3-3 Purchased No 250 Each 186.0000 2

 Cherry Rivet

Location	Loc Qty	Loc Code
ST311	186	
112314	4	
113539	44	
113973	138	

ALS4-1032-130 Purchased No 250 Each 927.0000 78

 Insert

Location	Loc Qty	Loc Code
PKG11	500	
114723	500	
ST281	292	
116049	292	
ST282	96	
110511	10	
115911	86	
ST381	39	
114654	39	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 25, 2011 10:25:07 AM

Page 4

Work Order ID: 65754

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011



Required Date: 1/31/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-15 Manufactured No 270 Each 18.0000 1
  91 11/02/09
 Gasket



Location	Loc Qty	Loc Code
FP	1	
56055	1	
FP011	16	
63568	16	
FP11	1	<u>Y1</u>
59238	1	

D3536-23 Manufactured No 270 Each 9.0000 1
  91 11/02/09
 Gasket

Location	Loc Qty	Loc Code
FP011	9	
63570	9	<u>Y1</u>

D3536-35 Manufactured No 270 Each 4.0000 1
  91 11/02/09
 Gasket

Location	Loc Qty	Loc Code
FP012	4	
58683	1	
63579	3	B65573

D3536-39 Manufactured No 270 Each 15.0000 1
  91 11/02/09
 Gasket

Location	Loc Qty	Loc Code
FP012	14	
63578	14	
FP12	1	<u>Y1</u>
58215	1	

Tuesday, January 25, 2011 10:25:08 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 25, 2011 10:25:08 AM

Page 5

Work Order ID: 65754

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011



Required Date: 1/31/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-15	Manufactured	No	270	Each	11.0000	1	1
							<u>XL 11/02/09</u>
Wearshoe							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	11	
63569	11	

D3535-35	Manufactured	No	270	Each	5.0000	1	1
							<u>XL 11/02/09</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP018	5	
63577	5	
		B65575

D3535-39	Manufactured	No	270	Each	21.0000	1	1
							<u>XL 11/02/09</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	8	
62945	8	
FP-18	13	
64076	13	

D3535-23	Manufactured	No	270	Each	13.0000	1	1
							<u>XL 11/02/09</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP021	12	
63571	12	

Tuesday, January 25, 2011 10:25:08 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 25, 2011 10:25:08 AM

Page 6

Work Order ID: 65754

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3

 Manufactured No
 Wearpad

270 Each 6.0000 1 1



11/02/09

Location

Loc Qty

Loc Code

FP17

6

BC5929

62705

6

D3537-1

 Manufactured No
 Wearpad

270 Each 92.0000 9 9



11/02/09

Location

Loc Qty

Loc Code

FP017

92


B65057

63997

20

64424

72

AN960C10L

 Purchased No
 washer

270 Each 25.0000 80 80



11/02/09

Location

Loc Qty

Loc Code


ST245

25

1116025

107534

25

AN960C416

 Purchased No
 washer

270 Each 29.0000 1 1



11/02/09

Location

Loc Qty

Loc Code

ST346

29

1115358

100993

29

X1

Tuesday, January 25, 2011 10:25:08 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 25, 2011 10:25:08 AM

Page 7

Work Order ID: 65754

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each

1,309.000 2 2



Phenolic Washer



JP 11/02/09

Location

Loc Qty

Loc Code

ST077

1309

42329

10

52505

299

64177

1000

u

x2

AN3C4A Purchased No

270 Each

1,172.000 80 80



BOLT



JP 11/02/09

Location

Loc Qty

Loc Code

ST350

1172

115300

25

116075

947

116590

200

x80

AN4C5A Purchased No

270 Each

447.0000 1 1



BOLT



JP 11/02/09

Location

Loc Qty

Loc Code

ST346

447

110552

1

112243

446

1116075

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, January 25, 2011 10:25:09 AM

Work Order ID: 65754

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 1/24/2011

Required Date: 1/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270 Each

84.0000 1 1



Aft Cap



11/02/09

Location

Loc Qty

Loc Code

FP-4

13

57332

13

xl

FP6

17

52663

3

62678

12

63633

2

Return 2010

54

62678

54

D3413-1

Manufactured No

270 Each

33.0000 1 1



Ring



11/02/09

Location

Loc Qty

Loc Code

ST420

17

62961

17

xl

ST473

16

51586

1

53446

5

65294

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

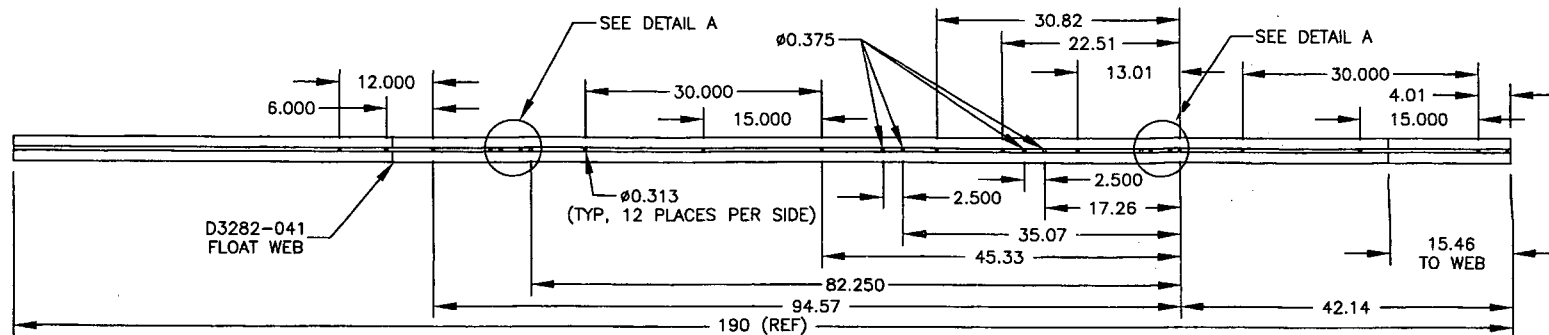
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

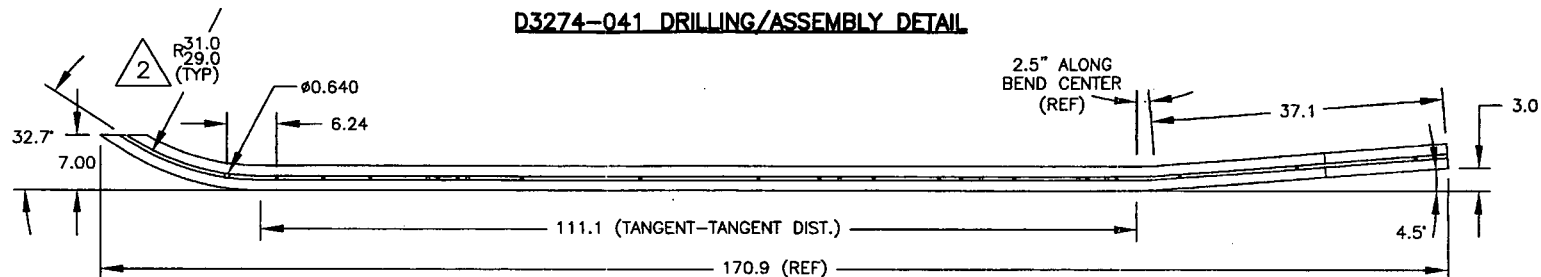
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

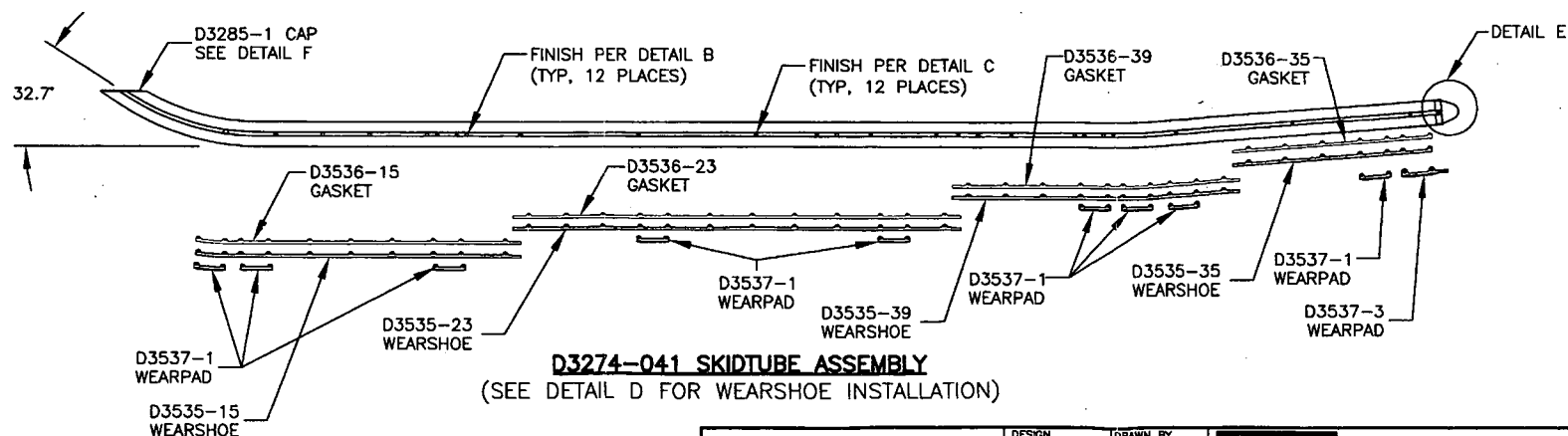
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

SHOWN
RETURN
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. U5754

R/H-01-25

RELEASED

07.02.12

COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

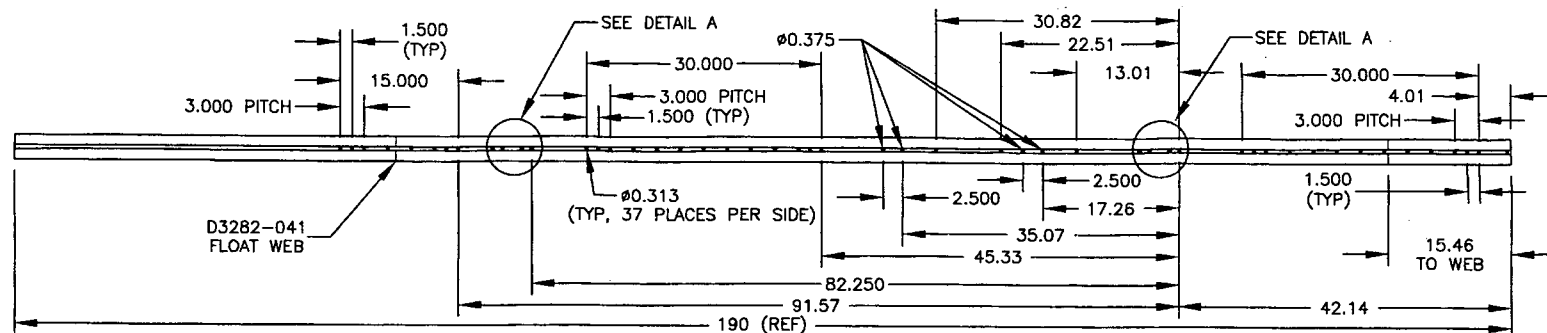
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

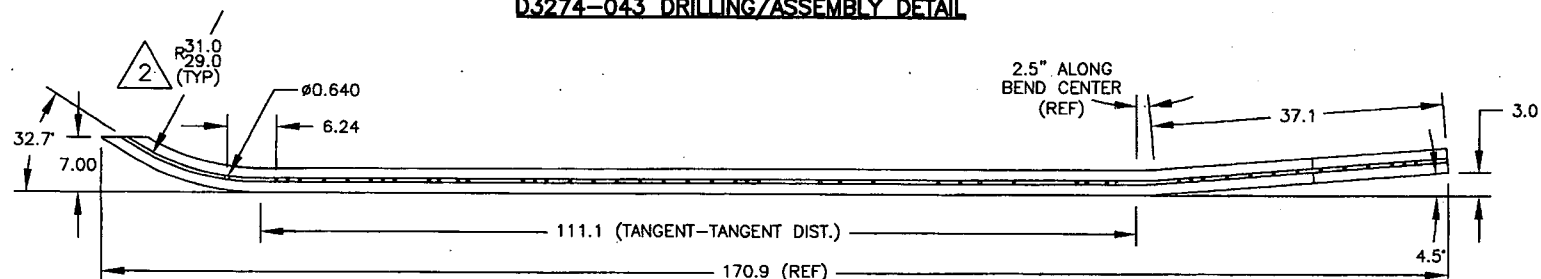
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

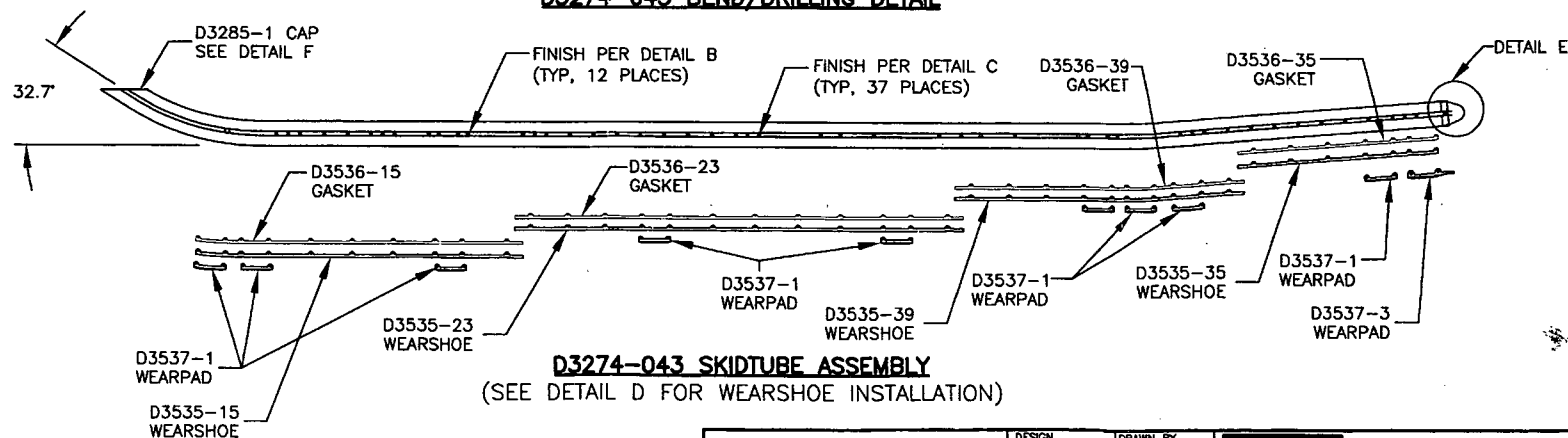
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

41065754

COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.		DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED	H	APPROVED	H	DRAWING NO. D3274	REV. D SHEET 3 OF 4
		DATE	06.12.19			TITLE SKIDTUBE ASSEMBLY	SCALE 1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

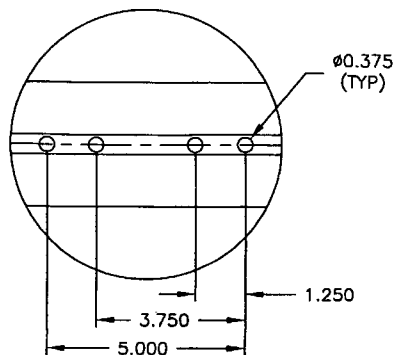
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

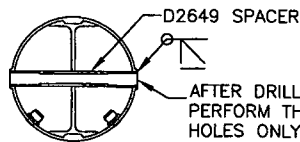
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

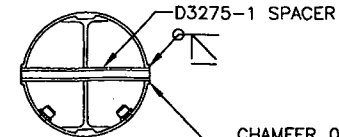


DETAIL B FOR 0.375 HOLES ONLY



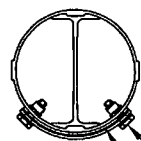
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

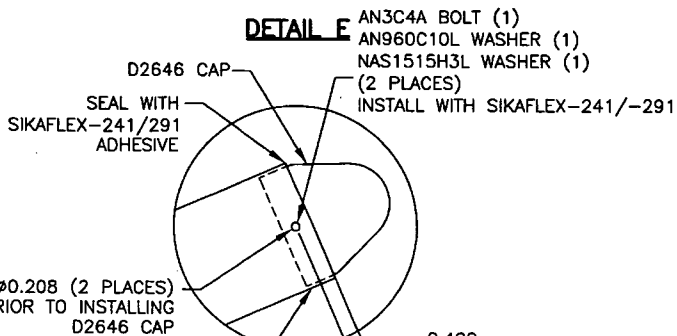
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



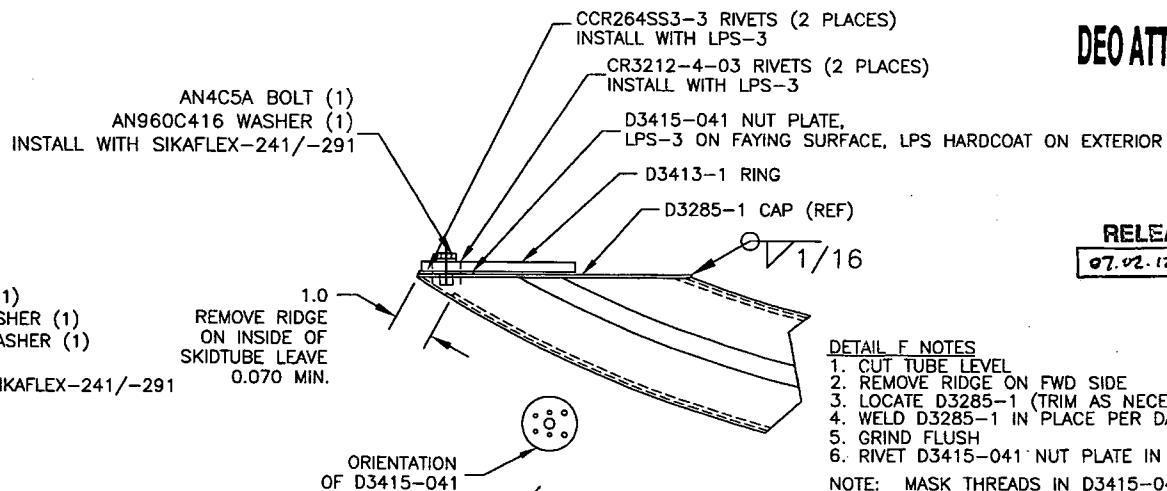
- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



ORIENTATION
OF D3415-041

DEO ATTACHED

RELEASED

07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

COPYRIGHT © 2004 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. 0
CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 4 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23		DATE 09.06.23		

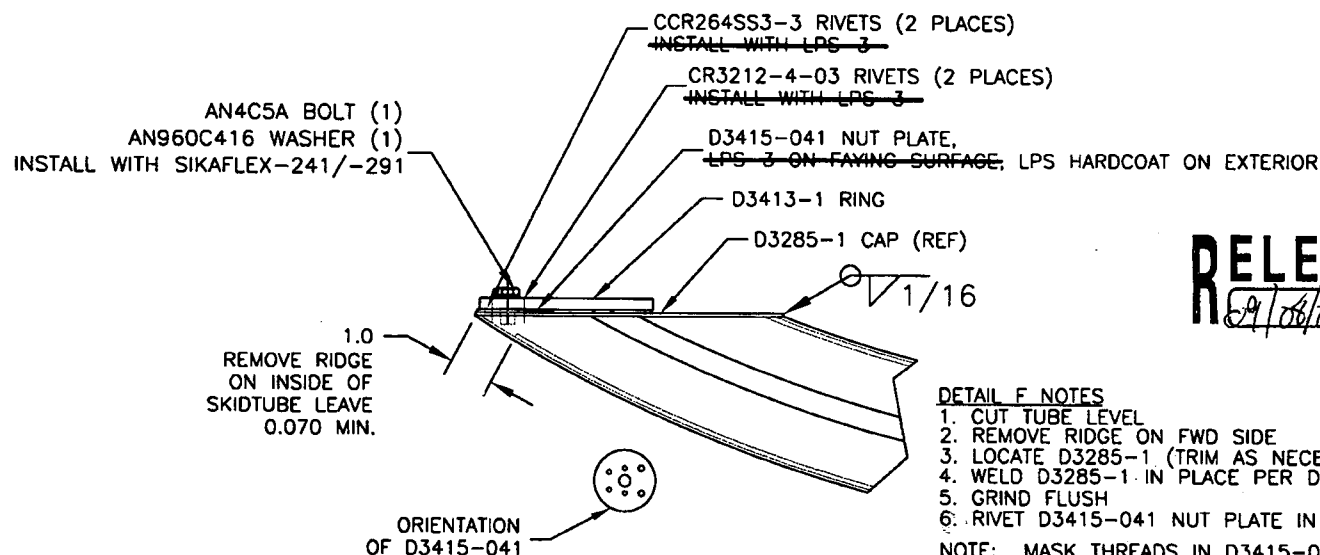
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

u/065754

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/06

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

COPYRIGHT © 2009 BY DART AEROSPACE USA, INC

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 242

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 65212
Part number: A 206-642-341
Description: 206 Skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Evans Date of Test Coupon 11-01-13

Welder Barclay Elliott Date of Test Coupon 11-01-13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld